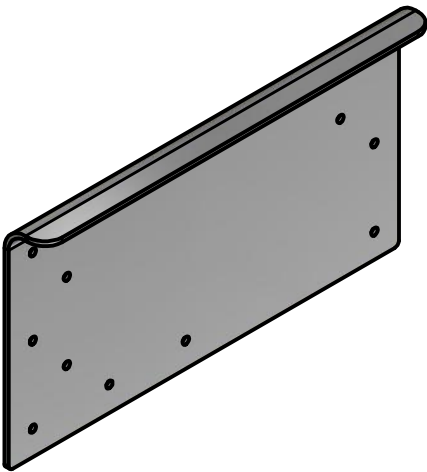
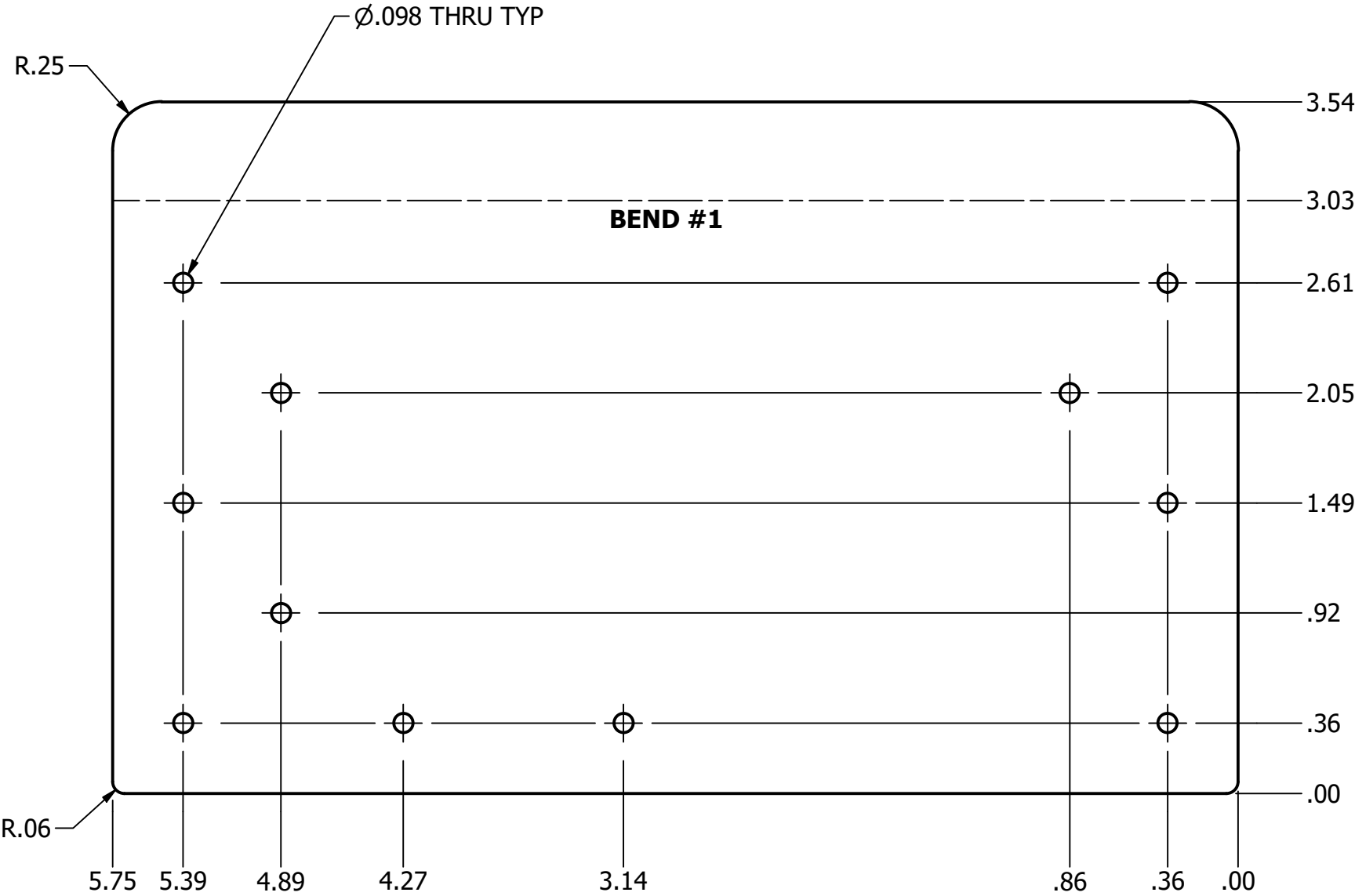
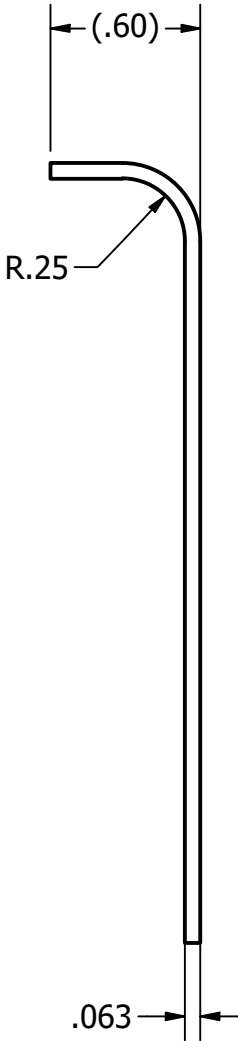
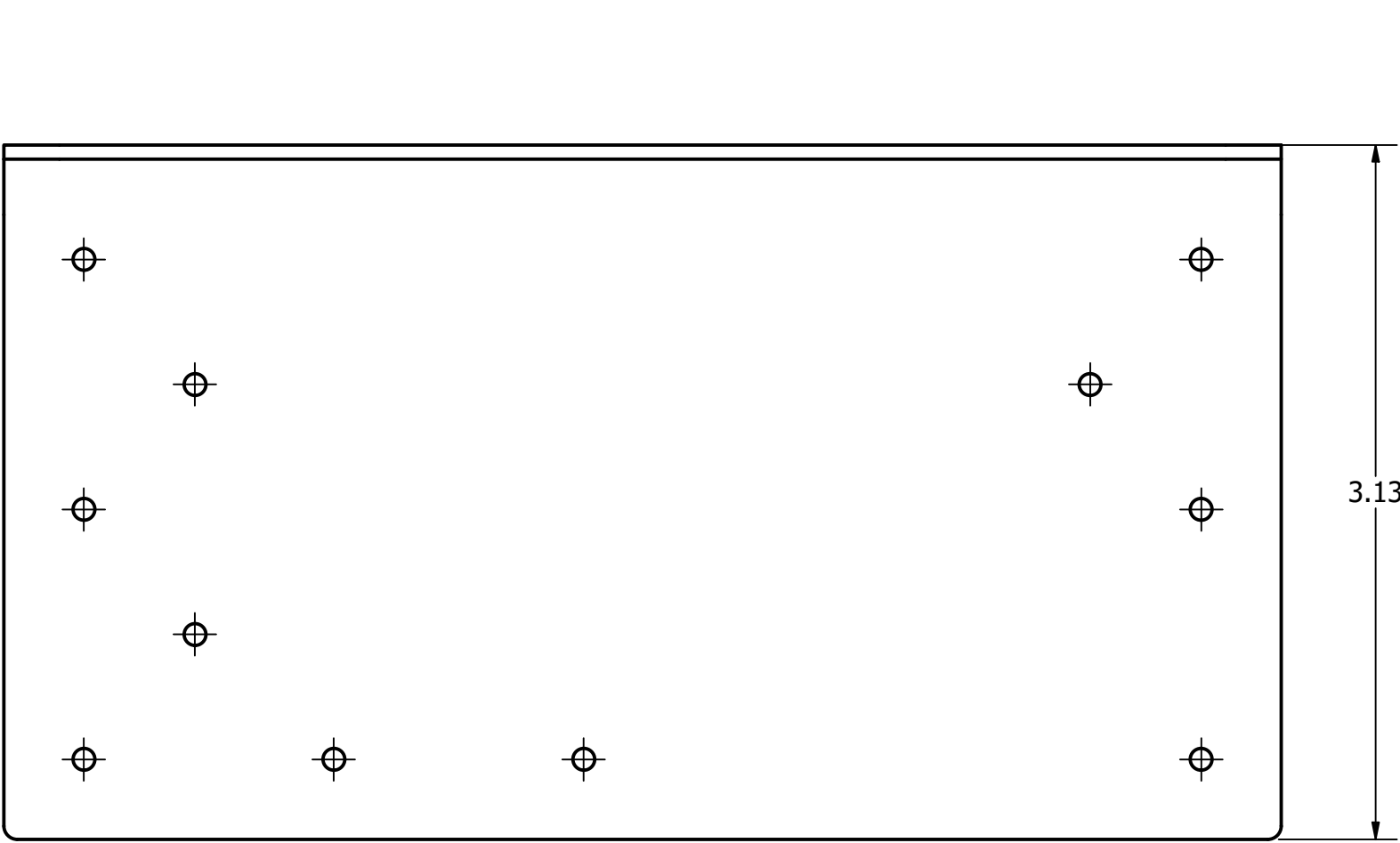


-1 DOUBLER

- NOTES:
- MATERIAL: 2024-T3 PER AMS-QQ-A-250/5
 - FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 - ALT FINISH: ANODIZE (COLOR OPT.) PER MIL-A-8625F TYPE II, CLASS 2 (OR EQUIV.)

REVISION HISTORY						
DATE	REV	ECO	DESCRIPTION	AUTHOR	CHECKED	APPROVED
9/30/20	A	-	ADDED -11, ALL: UPDATED FINISH SPEC TO MIL-PRF-23377J PRIMER WITH ANODIZE AS ALT.; -1 & -2: CHANGED TO 0.063 THICK 2024-T3	CMK	ꠔꠔ	CMK



FLAT PATTERN

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DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015
.X \pm .1
.XX \pm .01
.XXX \pm .005
ANGLES \pm 1°
THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
DRAWN	BNS	1/30/09
CHECKED	LS	1/30/09
APPROVED	REB	1/30/09
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DOCUMENT TITLE

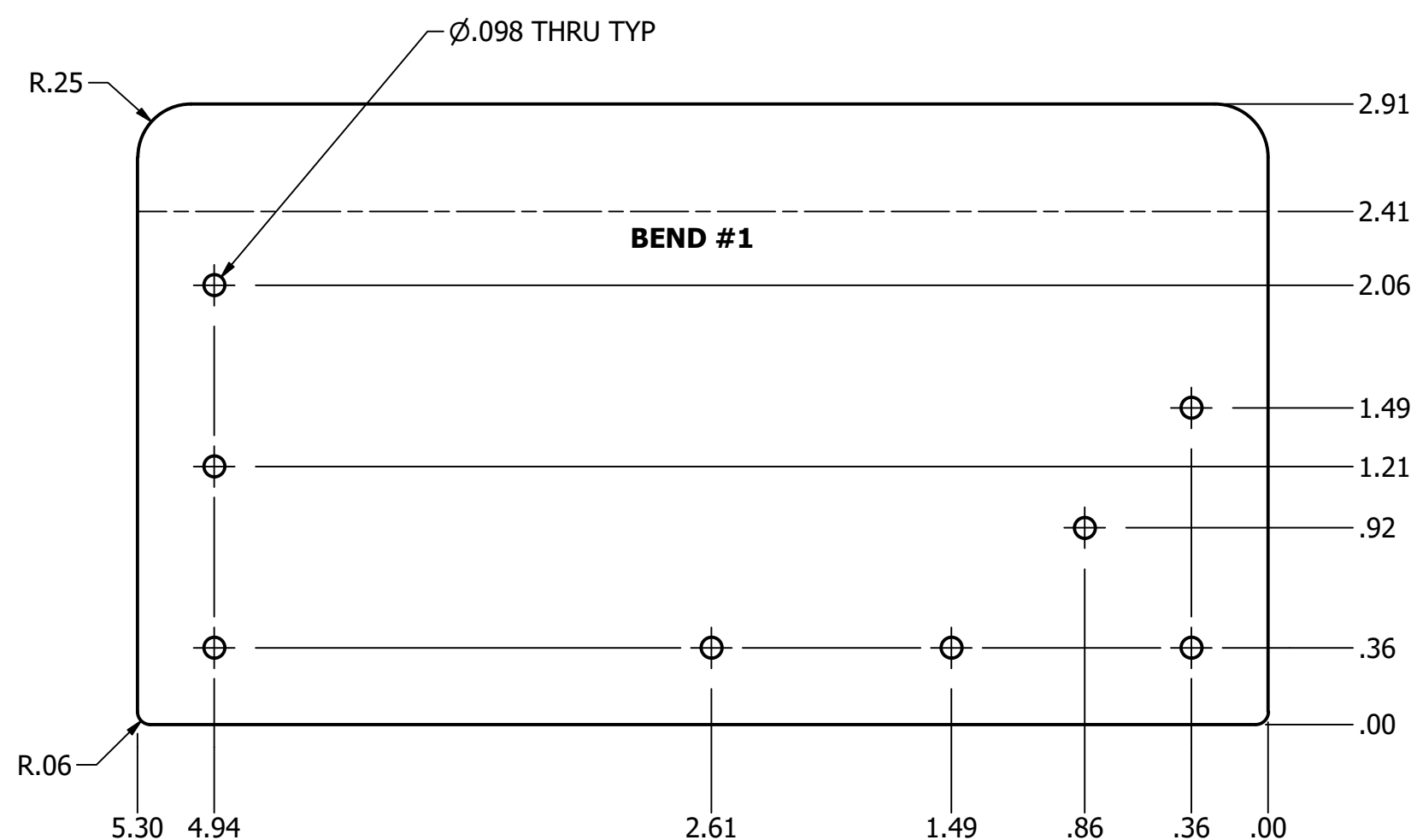
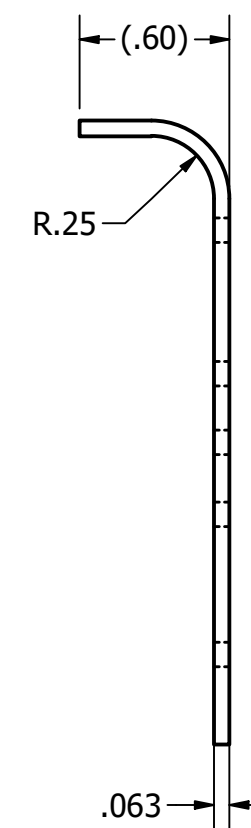
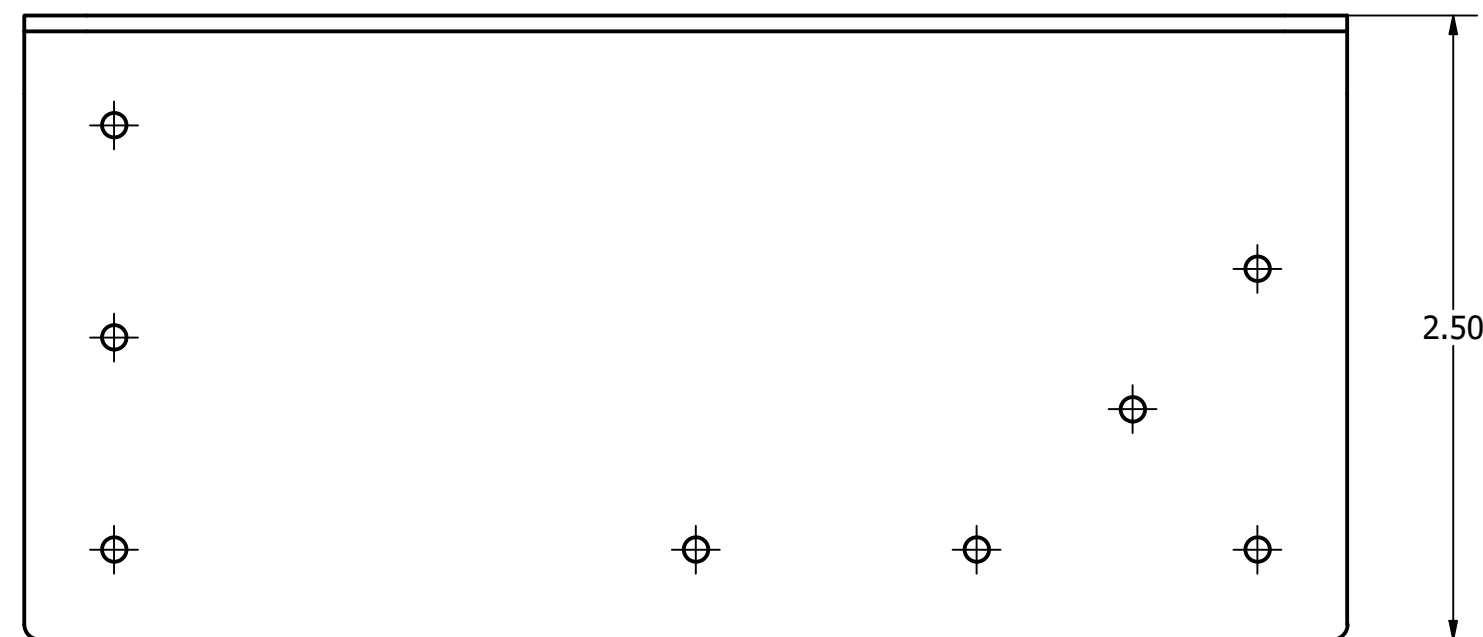
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DRAWING NUMBER	CAGE CODE	REV	ECO
C208ELP-2130	3CMA0	A	-
DO NOT SCALE DRAWING	SHEET 1 OF 6		

-2 DOUBLER

NOTES:

1. MATERIAL: 2024-T3 PER AMS-QQ-A-250/5
2. FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
3. ALT FINISH: ANODIZE (COLOR OPT.) PER MIL-A-8625F TYPE II, CLASS 2 (OR EQUIV.)





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DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: ✓¹²⁵
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

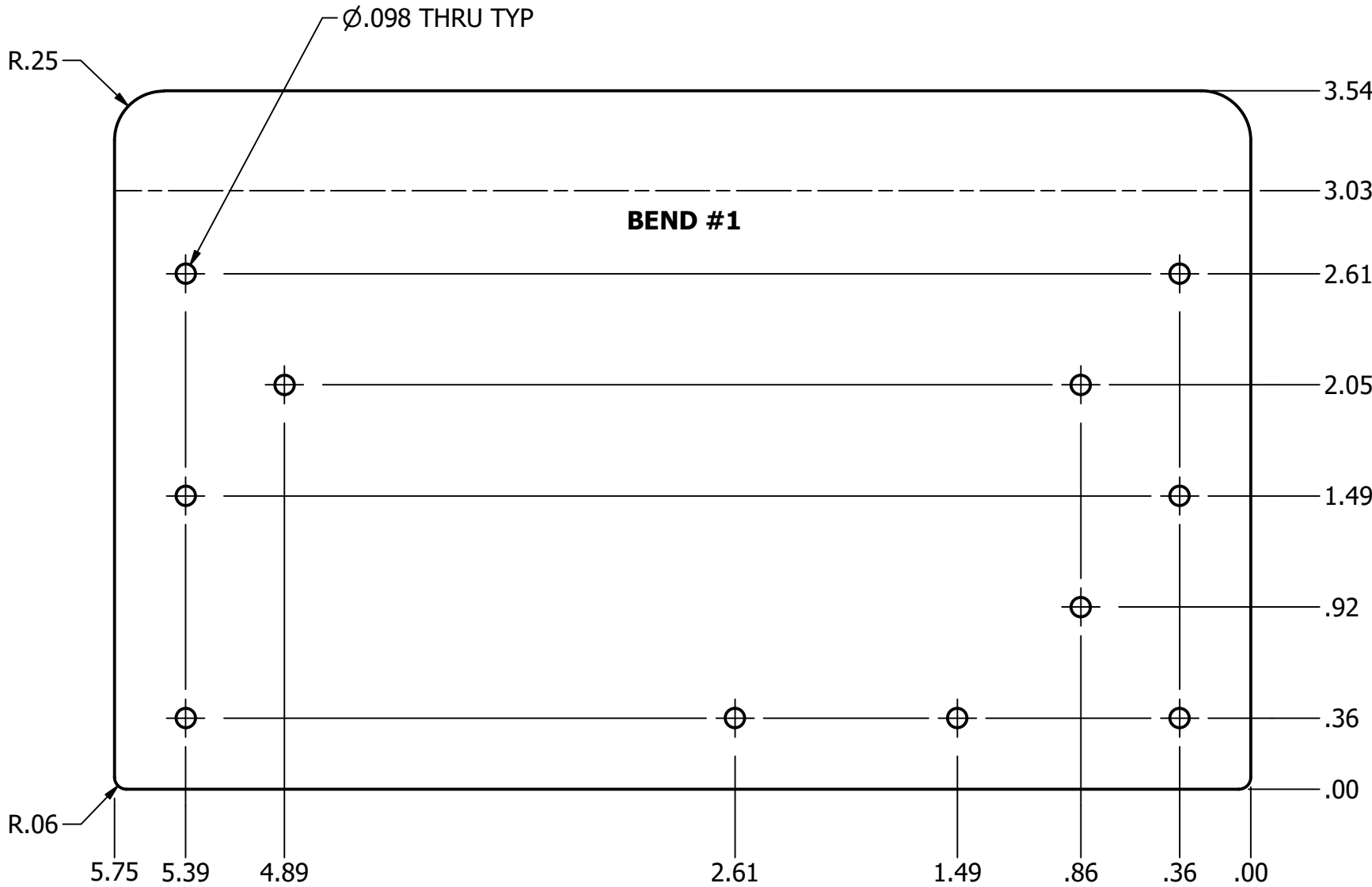
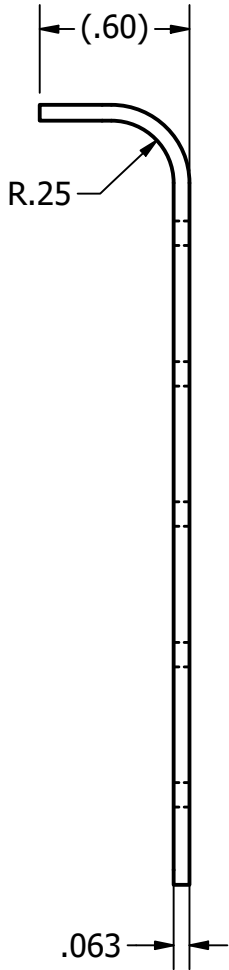
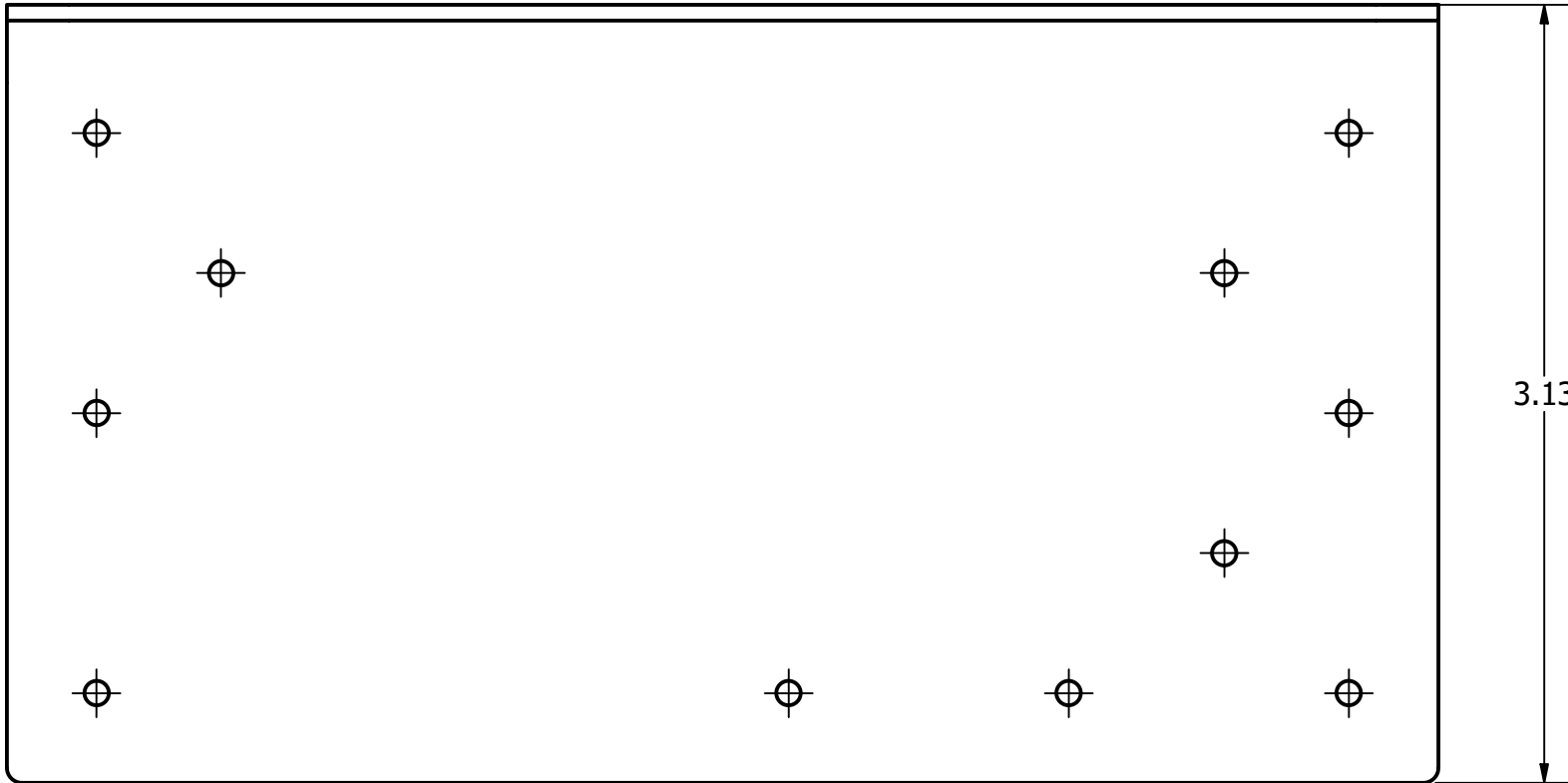
.X ±.1	THREADS
.XX ±.01	INTERNAL: CLASS 2B
.XXX ±.005	EXTERNAL: CLASS 2A
ANGLES ±1°	

APPROVALS		DATE
DRAWN	BNS	1/30/09
CHECKED	LS	1/30/09
APPROVED	REB	1/30/09
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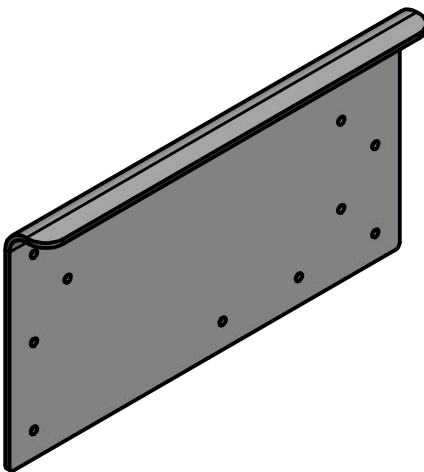
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C208ELP-2130		3CMA0	A	-
DO NOT SCALE DRAWING		SHEET 2 OF 6		

-11 DOUBLER

- NOTES:
1. MATERIAL: 2024-T3 PER AMS-QQ-A-250/5
 2. FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 3. ALT FINISH: ANODIZE (COLOR OPT.) PER MIL-A-8625F TYPE II, CLASS 2 (OR EQUIV.)



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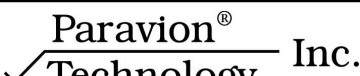
UNLESS OTHERWISE SPECIFIED
DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
DRAWN	BNS	1/30/09
CHECKED	LS	1/30/09
APPROVED	REB	1/30/09
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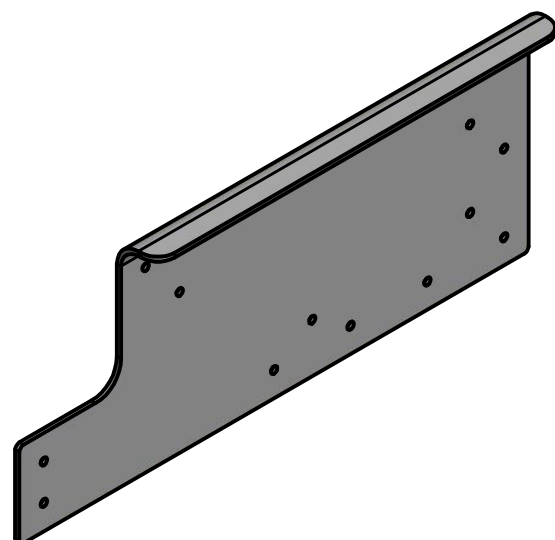
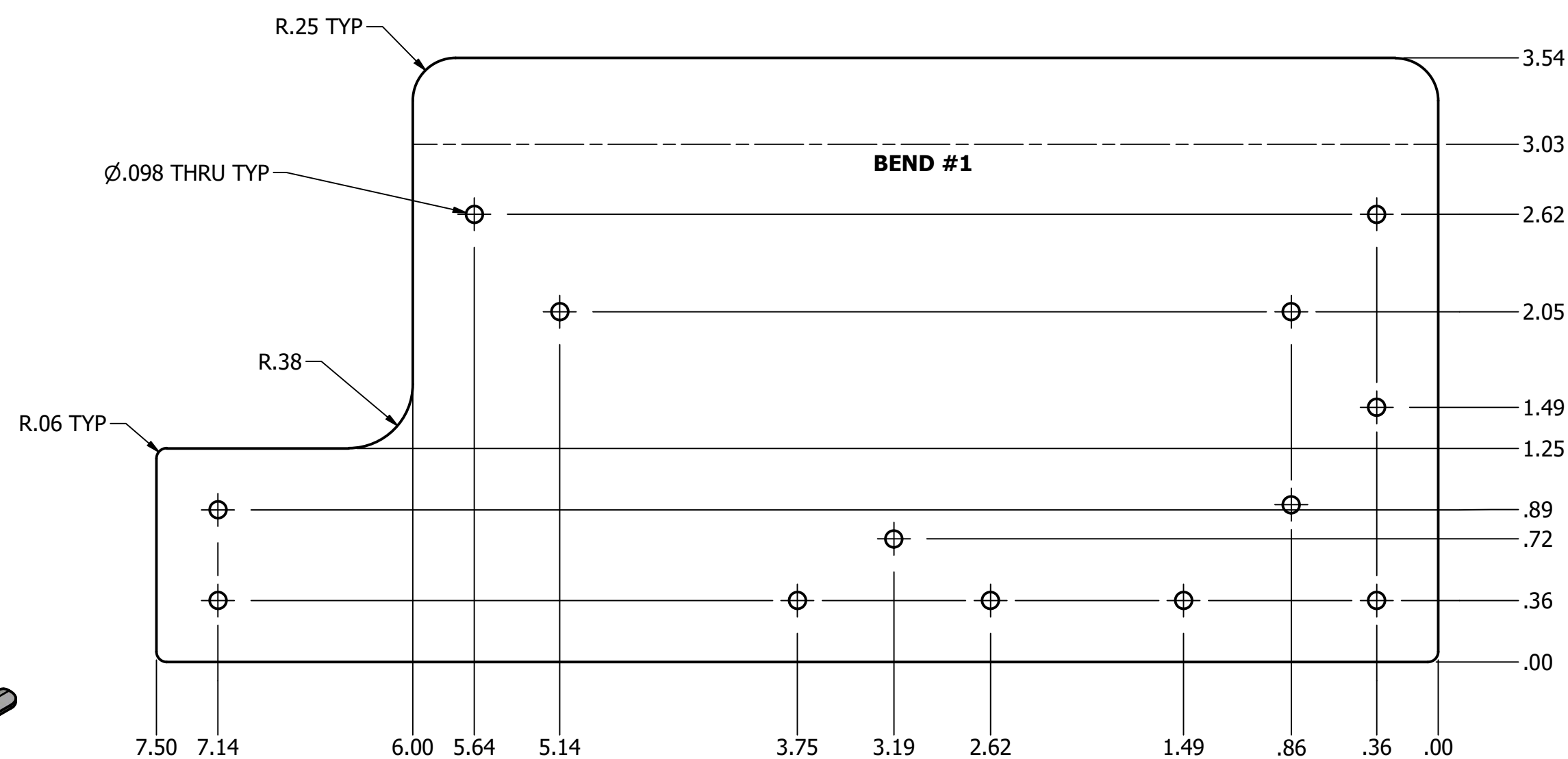
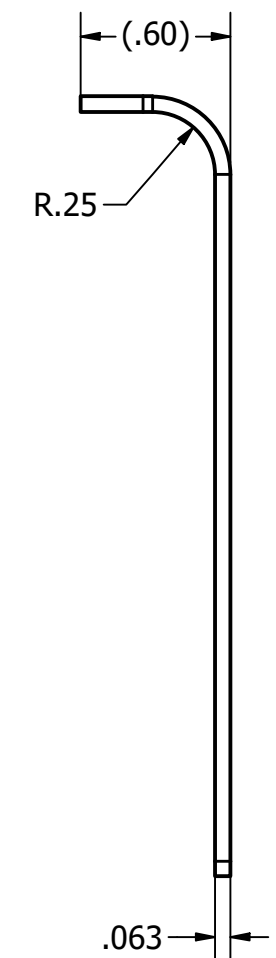
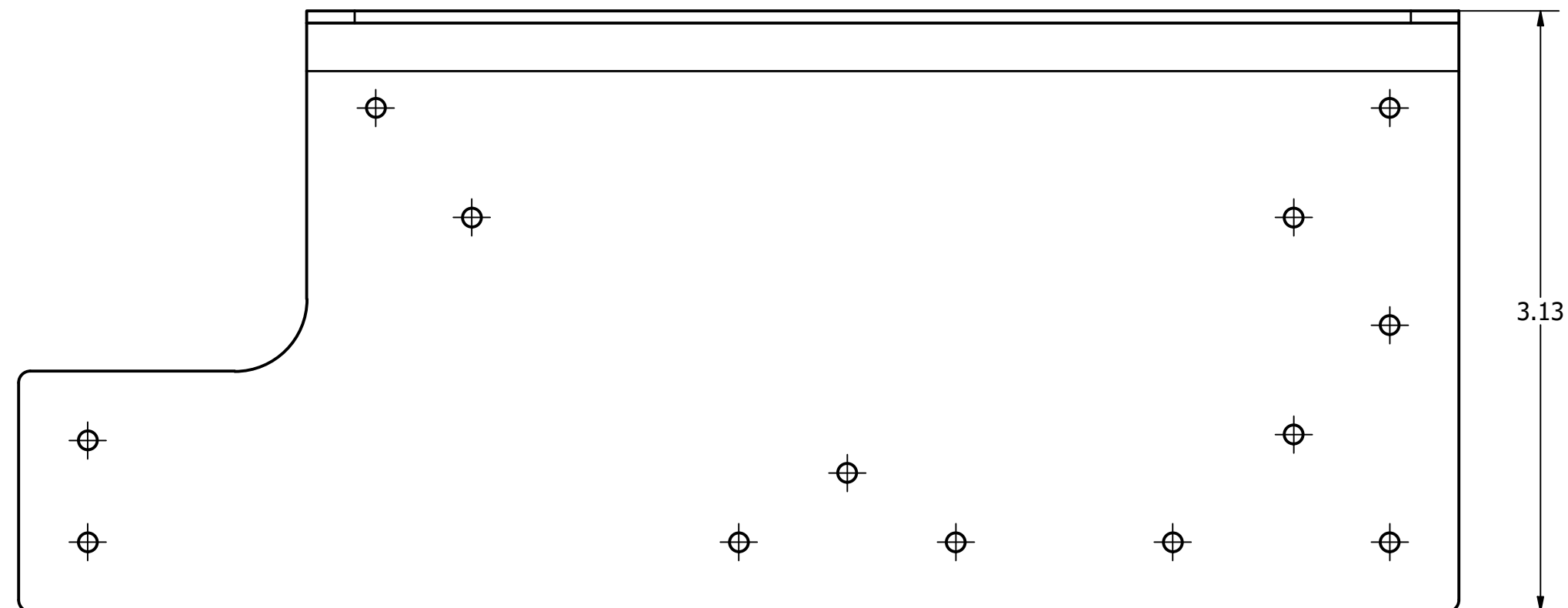


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DOCUMENT TITLE				
DOUBLER				
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C208ELP-2130		3CMA0	A	-
DO NOT SCALE DRAWING		SHEET 3 OF 6		

-12 DOUBLER

NOTES:

1. MATERIAL: 2024-T3 PER AMS-QQ-A-250/5
2. FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
3. ALT FINISH: ANODIZE (COLOR OPT.) PER MIL-A-8625F TYPE II, CLASS 2 (OR EQUIV.)




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PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: ¹²⁵ ✓
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
DRAWN	BNS	1/30/09
CHECKED	LS	1/30/09
APPROVED	REB	1/30/09
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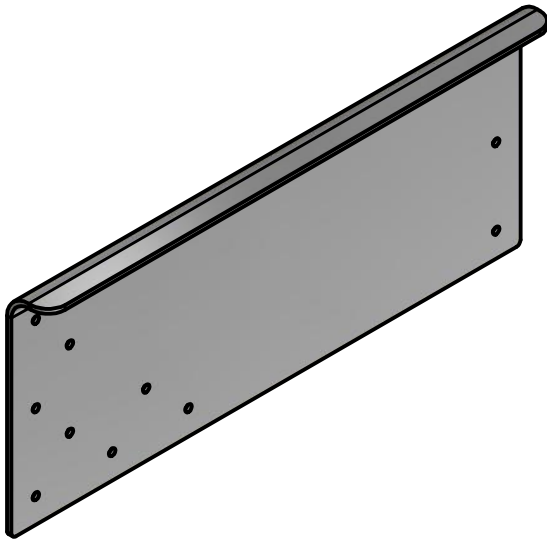
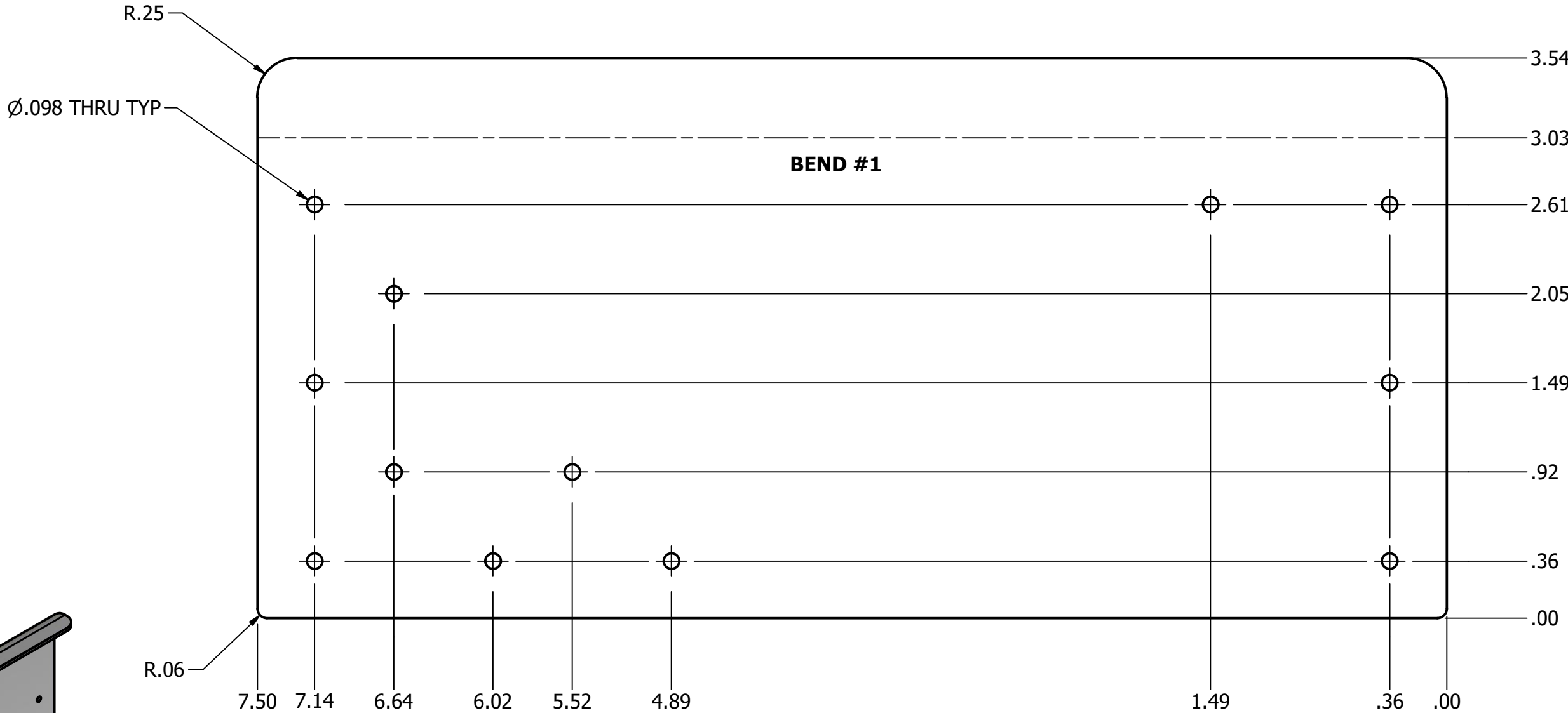
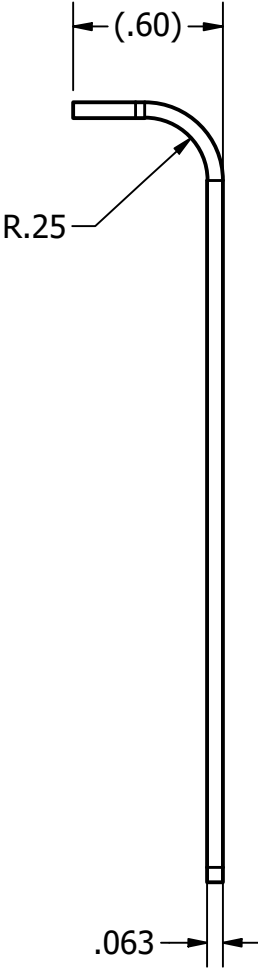
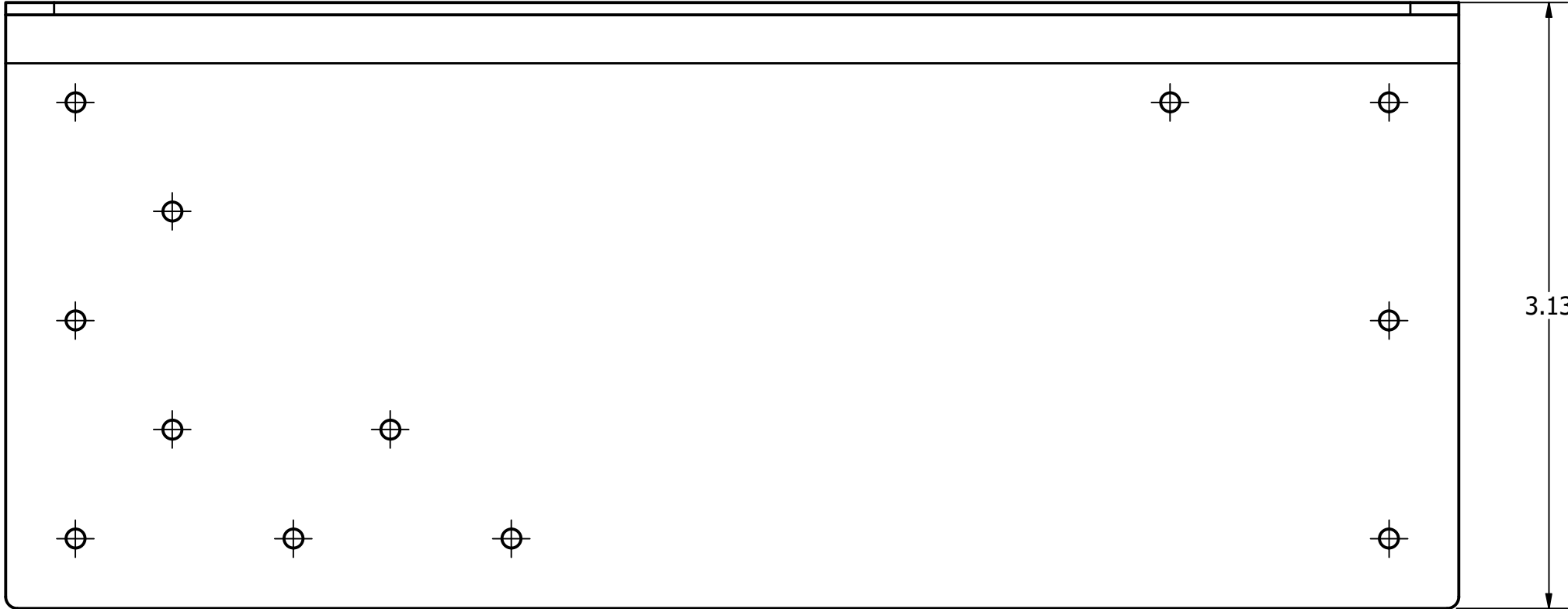
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DOCUMENT TITLE	DOUBLER
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C208ELP-2130		3CMA0	A	-
DO NOT SCALE DRAWING		SHEET 4 OF 6		

-13 DOUBLER

- NOTES:
- 1. MATERIAL: 2024-T3 PER AMS-QQ-A-250/5
 - 2. FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
 - 3. ALT FINISH: ANODIZE (COLOR OPT.) PER MIL-A-8625F TYPE II, CLASS 2 (OR EQUIV.)



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UNLESS OTHERWISE SPECIFIED
DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: R_a
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

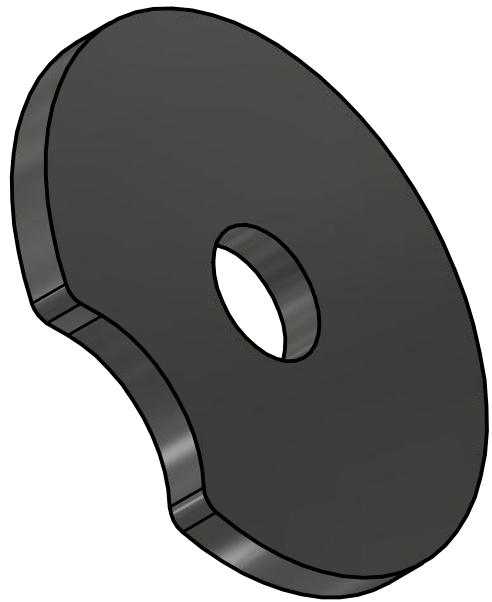
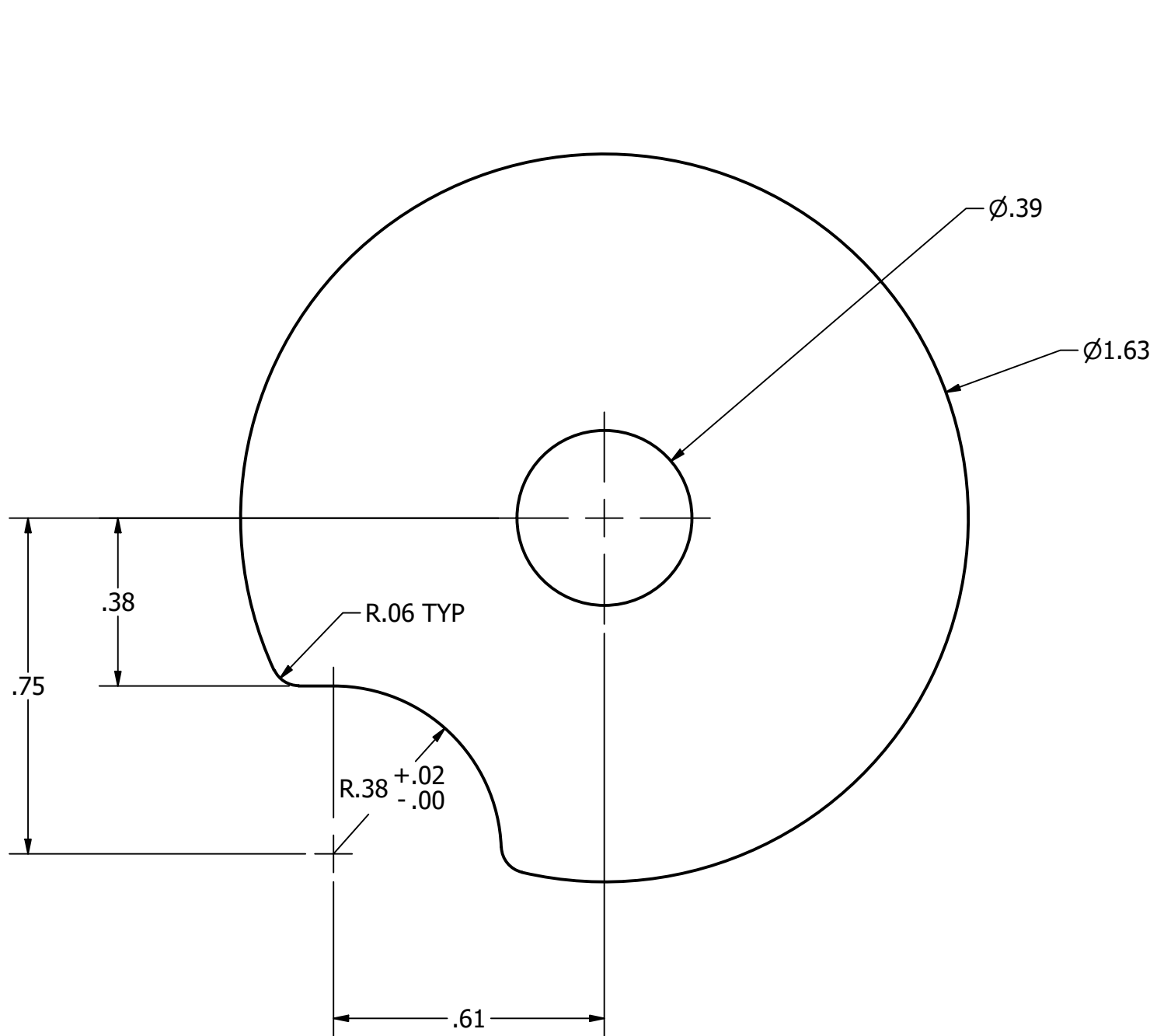
APPROVALS		DATE
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CHECKED	LS	1/30/09
APPROVED	REB	1/30/09

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DOCUMENT TITLE DOUBLER					
DRAWING NUMBER C208ELP-2130		CAGE CODE 3CMA0	REV A	ECO -	
DO NOT SCALE DRAWING			SHEET 5 OF 6		

-21 DOUBLER

- NOTES:
1. MATERIAL: AISI 4130 STEEL PER MIL-S-18729C, AMS 6351, OR AMS6350
 2. FINISH: ZINC PLATE PER ASTM B633-07 TYPE II, CLASS 3, SC3



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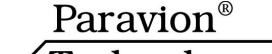
UNLESS OTHERWISE SPECIFIED
DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: $R\sqrt{1.6}$
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X $\pm .1$
.XX $\pm .01$
.XXX $\pm .005$
ANGLES $\pm 1^\circ$

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
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CHECKED	LS	1/30/09
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DOUBLER				
DRAWING NUMBER		CAGE CODE	REV	ECO
C208ELP-2130		3CMA0	A	-
DO NOT SCALE DRAWING		SHEET 6 OF 6		